

Date: Wednesday, 2/15/2006 9:16:18 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PATIENT STOP ASSEMBLY	
Job Number	: 25266		Part Number	: D2493	
Estimate Number	: 10949		Drawing Number	: D2493 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/15/2006	S.O. No. : N/A	Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 12/15/2005	Type : MACHINED PARTS	Due Date	: 1/10/2006	
Previous Run	: N/A		Qty:	<input checked="" type="checkbox"/>	Um: Each
Written By	: SEE COMMENT BELOW				
Checked & Approved By	: SEE ABOVE USER				
Comment	: Est. C 03.01.17 Reformat; Incorporated D2492 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S080	5052-H32 .080 Sheet
		Comment: Qty.: 1.9140 sf(s)/Unit Total : 36.3669 sf(s) 5052-H32 .080 Sheet Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch _____
2.0	SHEAR	SHEAR
		Comment: SHEAR Shear blanks: 8.000" x 25.942" Machine per Folio FA041 and Dwg D2492 Identify as D2492
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr Form using Jig DT2482B
5.0	POWDER COATING	POWDER COATING
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 0054.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 D2444

Pip Pin Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pip Pin Assembly

Pick:

Qty	Part Number	Description	Batch
2	D2444	Pip Pin	5B25272 2-B26767

11 B 25811

8.0 D2492

Patient Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 19.0000 Each(s)

Patient Stop

Pick:

Qty	Part Number	Description	Batch
1	D2492	Patient Stop	B25271

9.0 AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 38.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960JD10	Washer	M19413

10.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 38.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	M18180

11.0 MS27039107

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 38.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS27039-1-07	Screw	12 M11660 B118057

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 9:16:18 AM
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Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2493. D2492 on BOM as material listed in Step 2.

Identify as D2493

SD 06/02/15 (9)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

 06-02-15 T

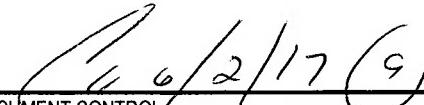
14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST179

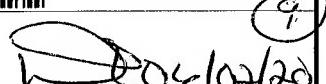
 6/2/17 (9)

15.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/02/20 (9) 

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

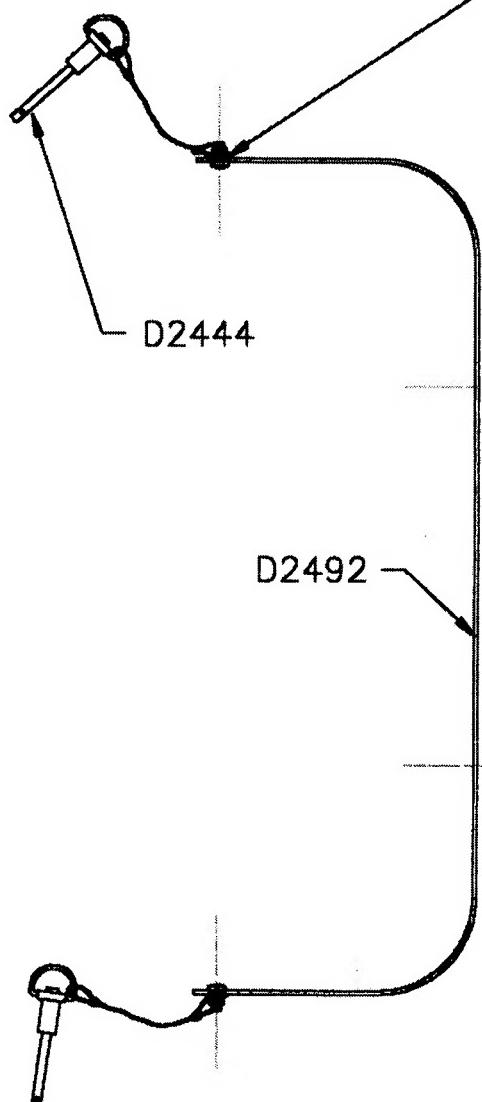
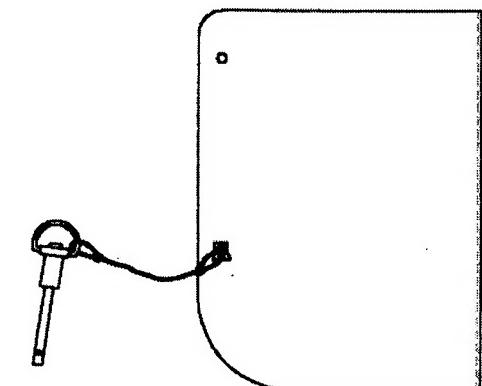
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

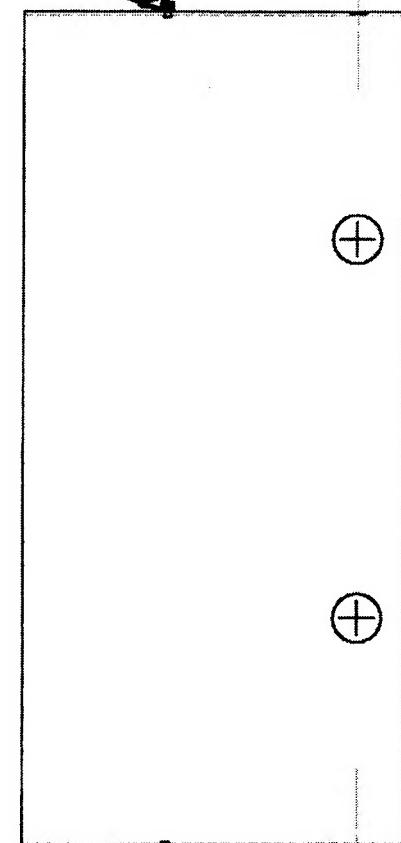
NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>bud</i>	APPROVED <i>J</i>	DRAWING NO. D2493	REV. A SHEET 1 OF 1
DATE 95:24:10		TITLE PATIENT STOP ASSEMBLY	SCALE 1:4

RELEASED
97/07/11 DS

D2492



MS27039-1-07 SCREW
AN960JD10 WASHER
MS21042L3 NUT
(2 PLACES)

Date: Thursday, 12/15/2005 3:57:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CÜ-DAR001 Dart Helicopters Services		Drawing Name	: PATIENT STOP ASSEMBLY		
Job Number	: 25266		Part Number	: D2493		
Estimate Number	: 10949		Drawing Number	: D2493 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/15/2005	S.O. No.	Type	MACHINED PARTS	Drawing Revision	: A
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 1/10/2006	Qty:	2 Um: Each
Previous Run	:					
Written By	:					
Checked & Approved By	:					
Comment	: Est. C 03.01.17 Reformat; Incorporated D2492 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S080	5052-H32 .080 Sheet	
		Comment: Qty.: 1.9140 sf(s)/Unit Total : 3.8281 sf(s) 5052-H32 .080 Sheet Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M1905Z	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Shear blanks: 8.000" x 25.942 Machine per Folio FA041 and Dwg D2492 Identify as D2492	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr Form using Jig DT2492B	
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 D2444 Pip Pin Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pip Pin Assembly

Pick:

Qty	Part Number	Description	Batch
2	D2444	Pip Pin	_____

8.0 D2492 Patient Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Patient Stop

Pick:

Qty	Part Number	Description	Batch
1	D2492	Patient Stop	_____

9.0 AN960JD10 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960JD10	Washer	_____

10.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	_____

11.0 MS27039107 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS27039-1-07	Screw	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2493. D2492 on BOM as material listed in Step 2.

Identify as D2493

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>bw</i>	APPROVED <i>g</i>	DRAWING NO. D2493
DATE 95:24:10	TITLE	SCALE 1:4

RELEASED
97/07/11 DS

MS27039-1-07 SCREW
AN960JD10 WASHER
MS21042L3 NUT
(2 PLACES)

